

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

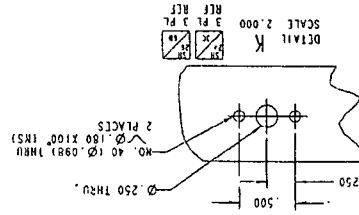
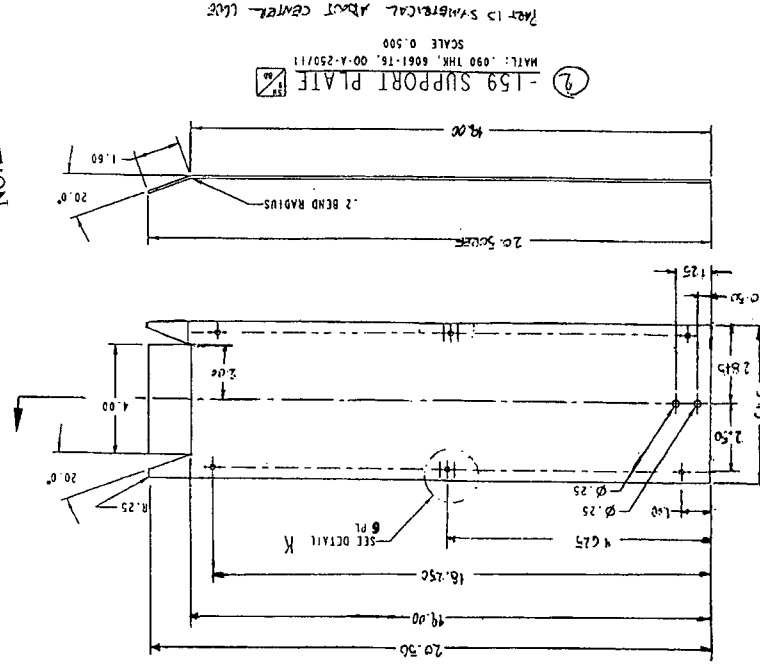
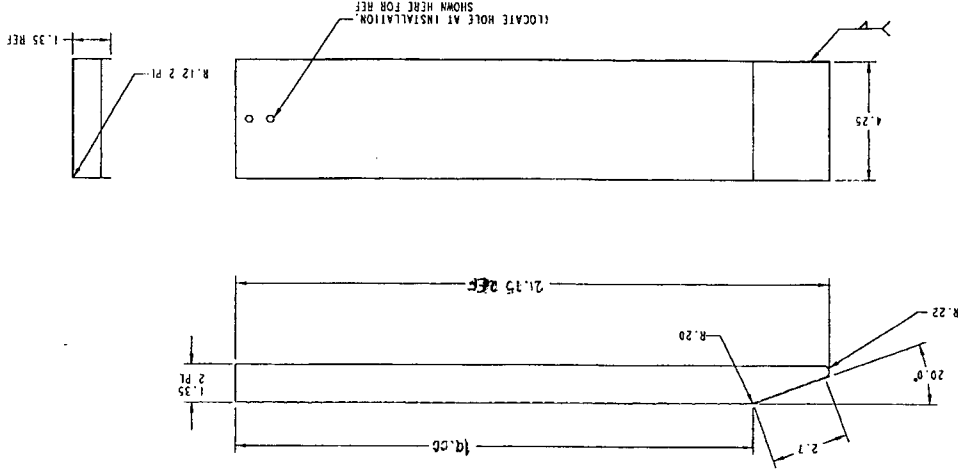
NOTE: Date & initial all entries

ORIGINAL

PREMIER AVIATION, INC.
2001 AVIATION PARKWAY, GRAND PRairie, ALABAMA 35897
D:\OSUV8 B67-43001
REV. 01
DATE: 08/15/01

② -13.20 DEGREE COVER PLATE
MATERIAL: .032 THK. 6061-T6, QQ-A-250/11
SCALE: 0.500

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 400244



RELEASED
JAN 11 2001

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Date: Friday, 7/4/2008 8:45:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE

Job Number: 40244

Part Number: PB674300171

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-install nut plates as per dwg B67-43001

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE

Job Number: 40244

Part Number: PB674300171

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- weld as per dwg B67-43001

SK 08.07.

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-grind weld flush

SAD 08.07.

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0

MS21075L3

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Nutplate

14.0

MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

RIVET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 8:45:48 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT PLATE
Job Number : 40244	
Estimate Number : 13385	
P.O. Number :	Part Number : PB674300171
This Issue : 7/4/2008 S.O. No. :	Drawing Number : B6743001 P.9/26
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B1
Previous Run : 40027	Material :
Written By : <u> </u>	Due Date : 7/10/2008 Qty: 10 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev:A 08-06-19 new issue DD verified by:ec	
Est Rev:B 08-06-27 procedure chg DD vried by:EC	<i>see first page</i>

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S090	6061-T6 .090 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.8594 sf(s)/Unit Total : 8.5943 sf(s)
6061-T6 .090 Sheet
batch: _____

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg B67-43001-159
Dwg Rev: _____
Prog Rev: _____
****grain direction along 5.750" ****
2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
Bend as per Dwg B67-43001

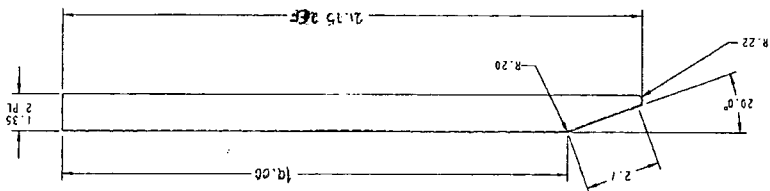
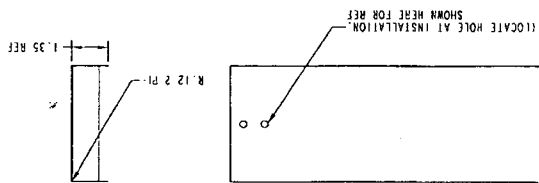
ORIGINAL

PREMIER AVIATION, INC.
2001 AVIATION PARKWAY, CHANDLER, ARIZONA 85226
D O S U V 8 B 6 7 - 4 3 0 0 1
SCALE: 28" = 1'-0"

REFERENCE ONLY

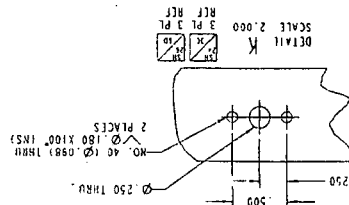
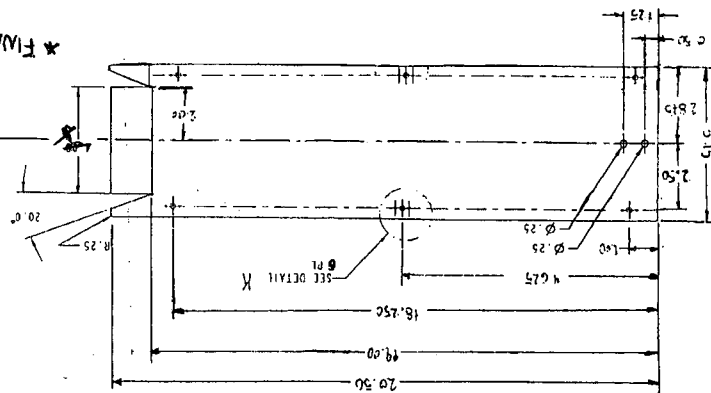
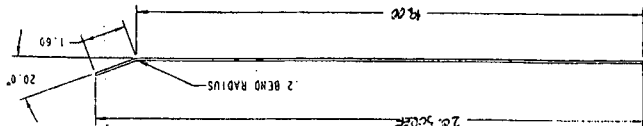
② - 13 20 DEGREE COVER PLATE
MATERIAL: 0.032 THK. 6061-T6, 00-A-250/11
SCALE: 0.500

* FINAL DIM OF BENDWY: 4.0



RELEASED
06-11-20

② - 159 SUPPORT PLATE
MATERIAL: 0.030 THK. 6061-T6, 00-A-250/11
SCALE: 0.500
Part 13 symmetrical about center line
40027



-159

☒ **First Article** ☐ **Prototype**

M19295

(714)

09/06/24

 $\mu/2$

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 1:02:21 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE

Job Number: 40027

Part Number: PB6743001159

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Doelias/aa

Job Completion



u of 08-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/06/27	7.1	Small fab grind weld flush	SAD	08/07/07	4		
	7.2	QC 10	SAD	08/07/07	14		
	7.3	QC 5	SAD	08/07/07	14		
	7.4	Hand Finish chemical conversion coat	SAD	08/07/07	14		
	7.5	QC 3	SAD	08/07/17	14		
		* All permanent change	NA	08/06/27			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 1:02:21 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE

Job Number: 40027

Part Number: PB6743001159

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/66/25 (+14)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- weld as per dwg B67-43001

08-06-27

8.0

MS21075L3

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Nutplate

M108601

08/07/17

9.0

MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

RIVET

M105978

08/07/17

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

2- install nut plates as per dwg B67-43001

08/07/17 (+14)

11.0

QC5

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/7/17 (+14)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 1114

08-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 1:02:21 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT PLATE
Job Number : 40027
Estimate Number : 13385
P.O. Number :
This Issue : 24/06/2008 S.O. No. :
Prsht Rev. : NC Part Number : PB6743001-71
First Issue : / / Type : SMALL /MED FAB Drawing Number : B6743001 PAGE26
Previous Run : Drawing Revision : B1
Written By : Due Date : 01/07/2008 Qty: 10 MF Um: Each
Checked & Approved By : MF 08-06-24
Comment : Est Rev:A 08-06-19 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S090 6061-T6 .090 Sheet



Comment: Qty.: 0.8594 sf(s)/Unit Total : 4.2971 sf(s)
6061-T6 .090 Sheet
batch: 19295 IB 8-6-24

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg B67-43001-159
Dwg Rev: B1 IB 8-6-24
Prog Rev: B1

****grain direction along 5.750" ****

2-Deburr if necessary IB 8-6-24

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
Bend as per Dwg B67-43001

4.1 Counter sink as per dwg

IB 08/06/25 (14)
EB 08/06/25 (14)

08/06/25 42 Qc 5